

FIG.1

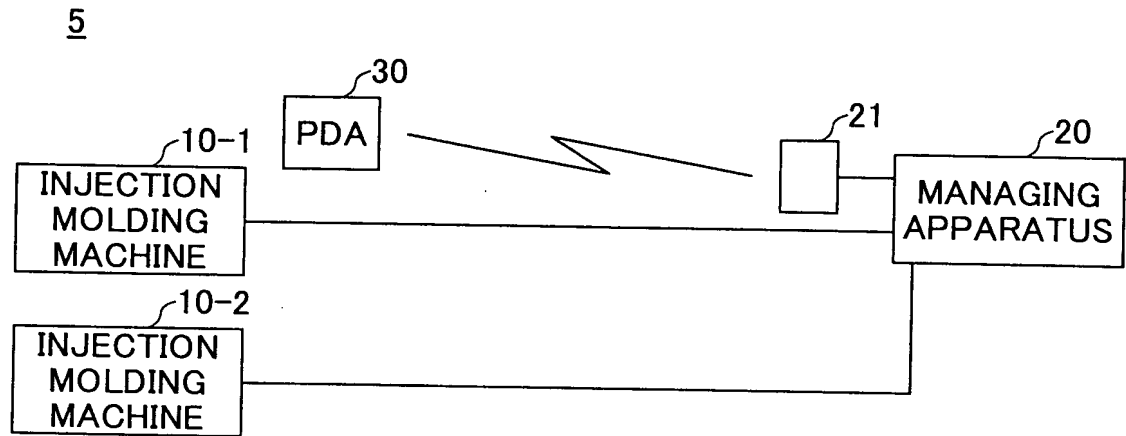


FIG.2

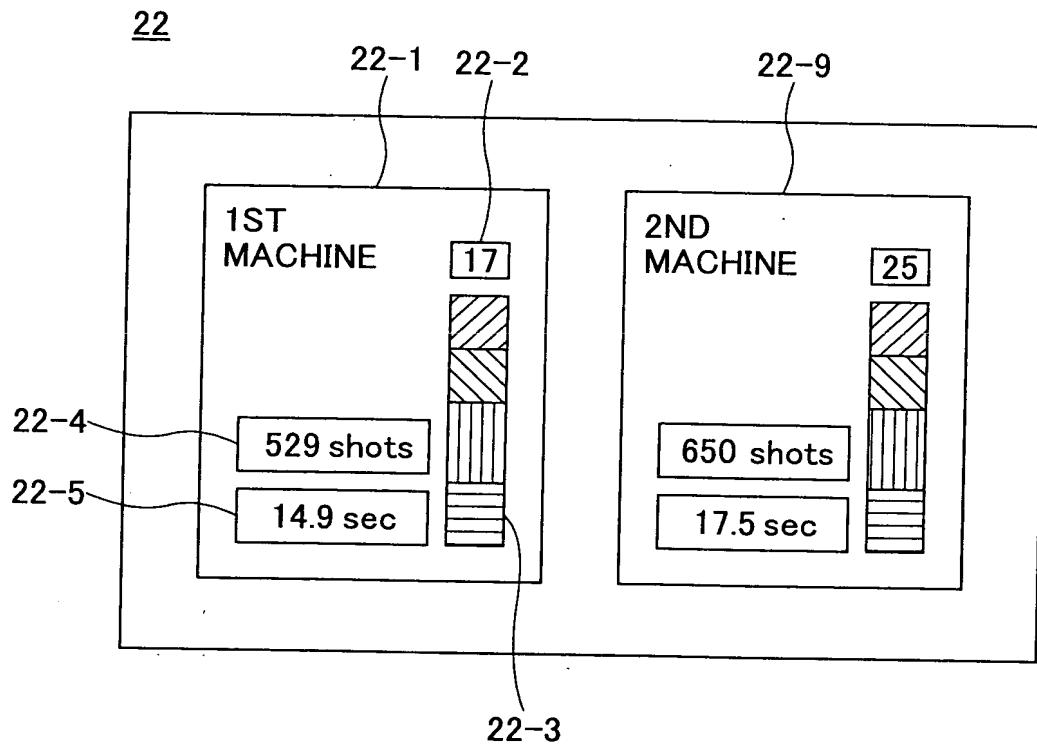


FIG.3

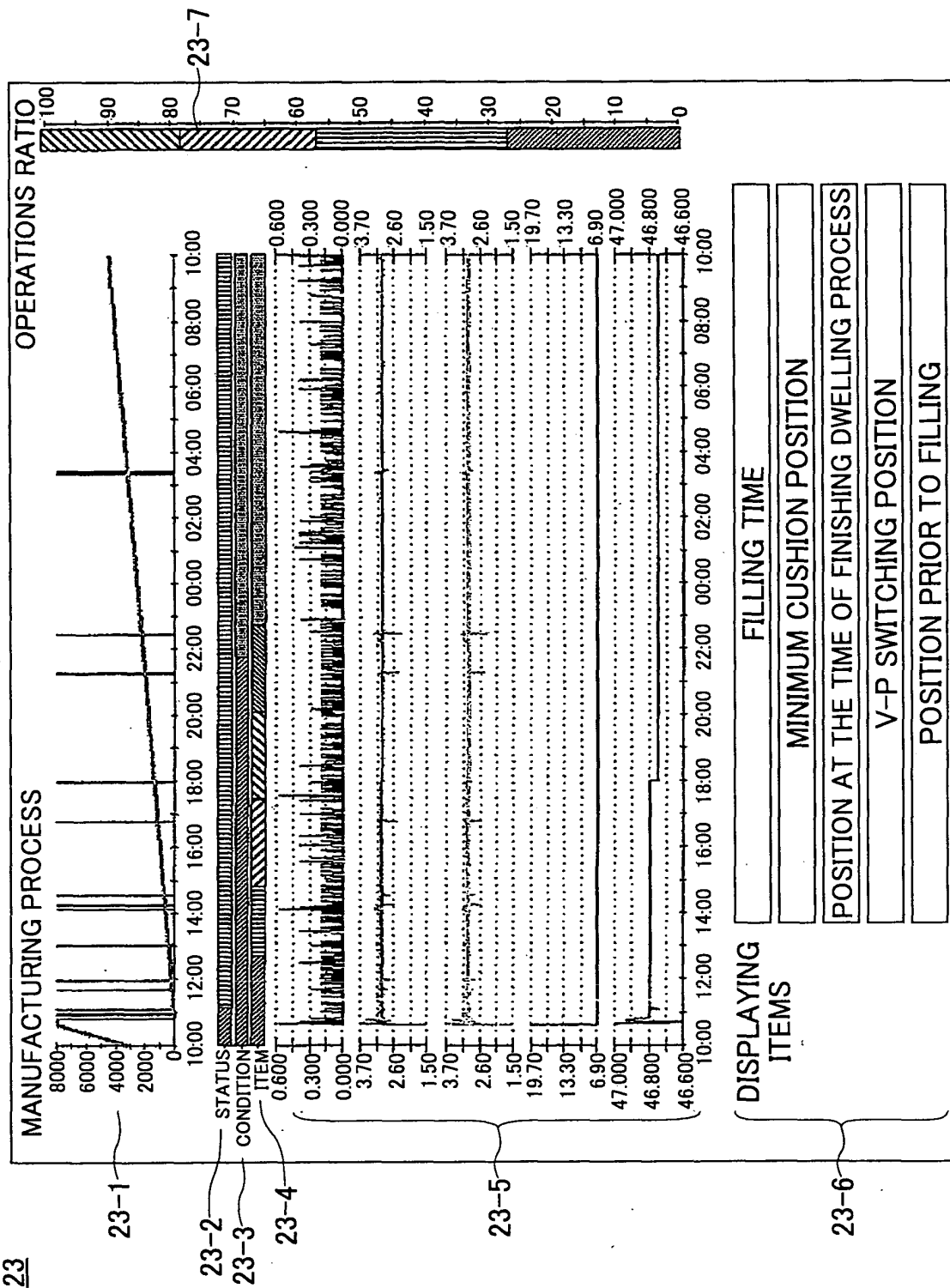


FIG.4

24

|                                 |                   |                  |                        |
|---------------------------------|-------------------|------------------|------------------------|
| 1ST MACHINE                     |                   |                  |                        |
| ITEMS                           | BEFORE<br>CHANGED | AFTER<br>CHANGED | DATE AND<br>TIME       |
| METERING<br>FINISHING POSITION  | 46.25             | 46.20            | 2003/06/05<br>14:15:20 |
| CYCLE MONITOR<br>MODE           | 0                 | 1                | 2003/06/05<br>10:20:15 |
| MOLD PROTECTION<br>MONITOR MODE | 0                 | 1                | 2003/06/05<br>10:20:15 |
| MAXIMUM CUSHION<br>MONITOR MODE | 0                 | 1                | 2003/06/05<br>10:20:15 |
| MINIMUM CUSHION<br>MONITOR MODE | 0                 | 1                | 2003/06/05<br>10:20:15 |

FIG.5

25

| 1ST MACHINE   |                                   |                                |
|---|-----------------------------------|--------------------------------|
| ITEMS   | TIME OF OCCURRENCE OF ABNORMALITY | TIME OF LIFTING OF ABNORMALITY |
| [ABNORMALITY]<br>MOLD PROTECTION                            | 2003/06/01<br>10:20:15            | 2003/06/02<br>14:15:10         |
| [INTER ROCK]<br>SAFETY DOOR OPEN                            | 2003/06/01<br>10:20:15            | 2003/06/02<br>14:15:10         |
| [INTER ROCK]<br>NOT FINISHED<br>MOLD CLAMPING<br>ADJUSTMENT | 2003/06/01<br>10:20:15            | 2003/06/02<br>14:15:10         |

FIG.6

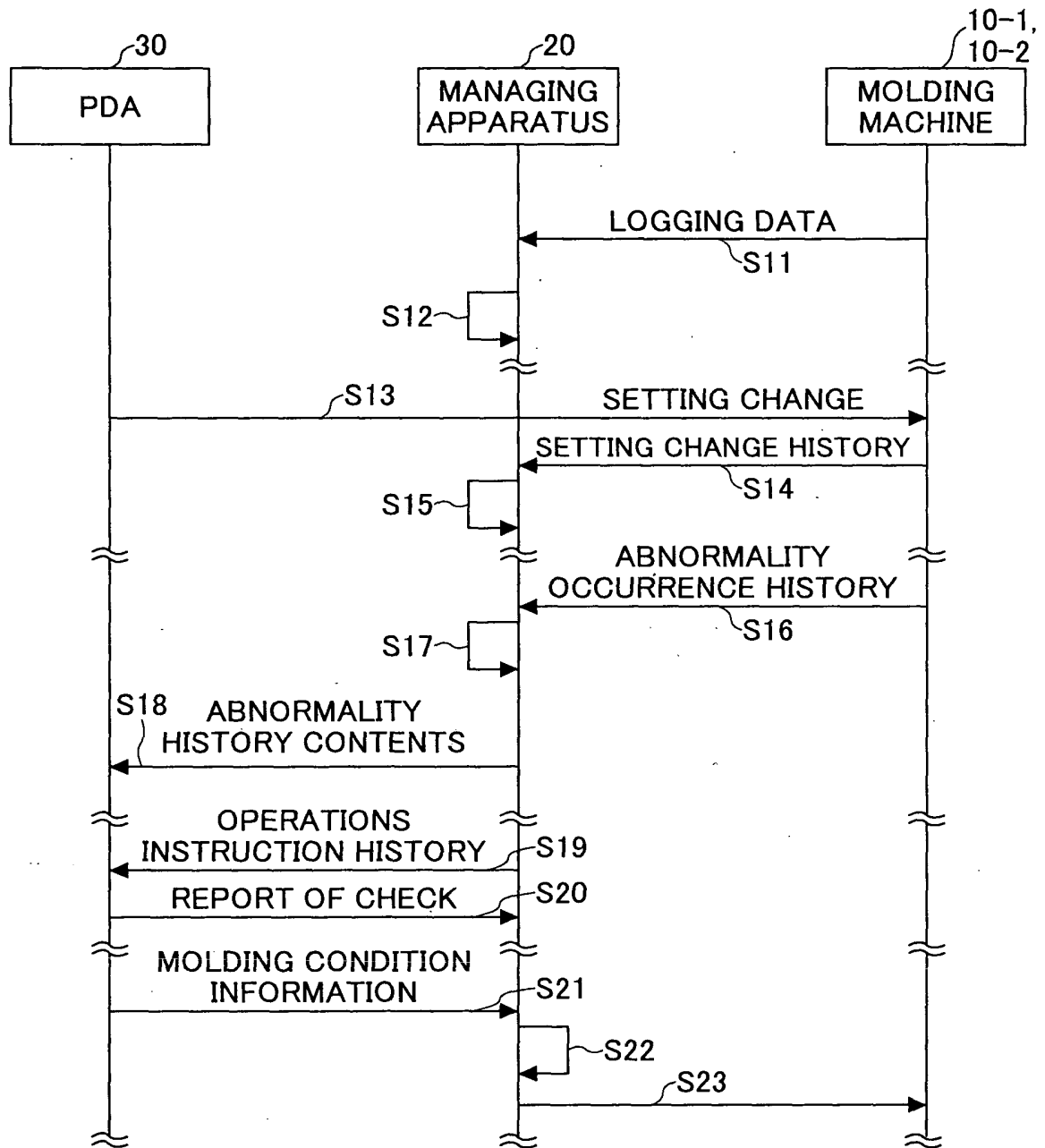
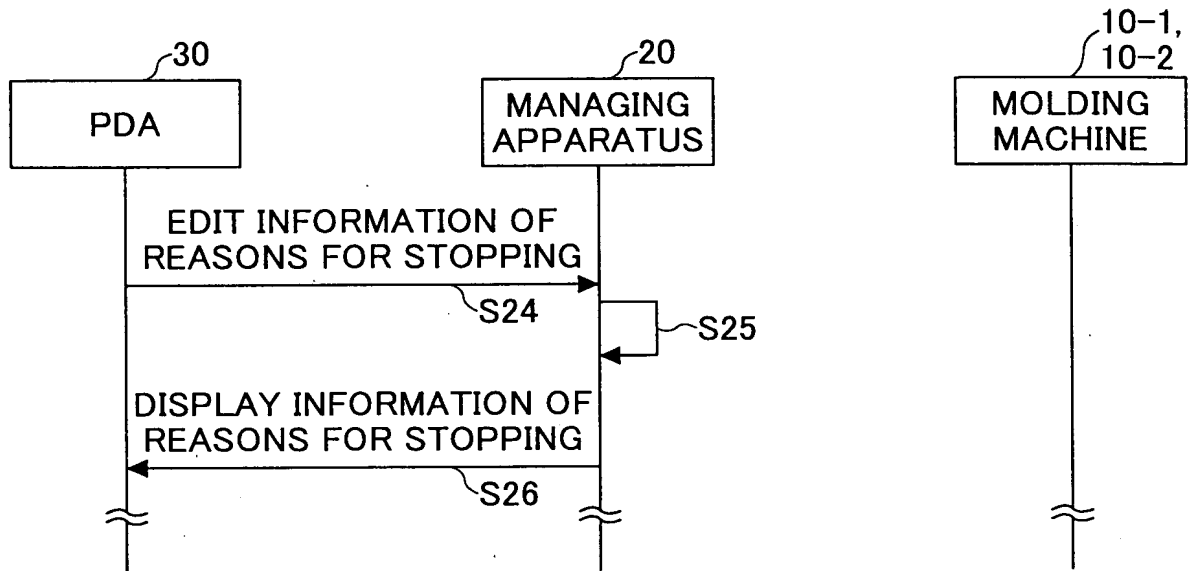


FIG.7



# FIG.8

60

61

61

62



EDIT

| 1ST MACHINE          |                    |                             |           |
|----------------------|--------------------|-----------------------------|-----------|
| MOLDING CONDITION    |                    | INITIAL                     |           |
| STATUS               | ABNORMALITY OCCURS | TIME OF STOPPING            | 000:01:15 |
| OCCURRENCE TIME      |                    | 03/05 11:06:09              |           |
| RESTART TIME         |                    | 03/05 11:07:24              |           |
| ABNORMALITY          |                    | [A000]CYCLE                 |           |
| SUPPLEMENT           |                    | MOLD PROTECTION ABNORMALITY |           |
| PERIPHERAL APPARATUS |                    | MOLD                        |           |
| REASON               |                    | PIN IS BROKEN               |           |
| OPERATOR             |                    | x x x x                     |           |
| MEMO                 |                    | REPAIRABLE                  |           |

FIG.9

70

|                               |  |                           |        |
|-------------------------------|--|---------------------------|--------|
|                               |  | MANUFACTURING INSTRUCTION |        |
| OPERATOR                      |  | x x x x                   |        |
| 1ST MACHINE                   |  | MOLDING MACHINE           |        |
| <div>▲ ▼</div>                |  | EDIT                      | RETURN |
| PRODUCT                       |  | FLOWERPOT                 |        |
| MOLDING CONDITION             |  | FLOWERPOT AB              |        |
| MOLD                          |  | FLOWERPOT 001             |        |
| MATERIAL                      |  | PP                        |        |
| ESTIMATED MANUFACTURED NUMBER |  | 1000                      |        |

FIG.10

80

OPERATOR x x x x

81 — 1ST MACHINE ▼

82 — SELECT MENU



FIG.11

85

86

|                      |                    |                             |           |
|----------------------|--------------------|-----------------------------|-----------|
| REGISTER             |                    | OPERATOR    x x x x         |           |
| 1ST MACHINE          |                    |                             |           |
| MOLDING CONDITION    |                    | INITIAL                     |           |
| STATUS               | ABNORMALITY OCCURS | TIME OF STOPPING            | 000:01:15 |
| OCCURRENCE TIME      |                    | 03/05 11:06:09              |           |
| RESTART TIME         |                    | 03/05 11:07:24              |           |
| ABNORMALITY          |                    | [A000]CYCLE                 |           |
| SUPPLEMENT           |                    | MOLD PROTECTION ABNORMALITY | ▼         |
| PERIPHERAL APPARATUS |                    | MOLD                        | ▼         |
| REASON               |                    | PIN IS BROKEN               | ▼         |
| MEMO                 |                    | REPAIRABLE                  |           |